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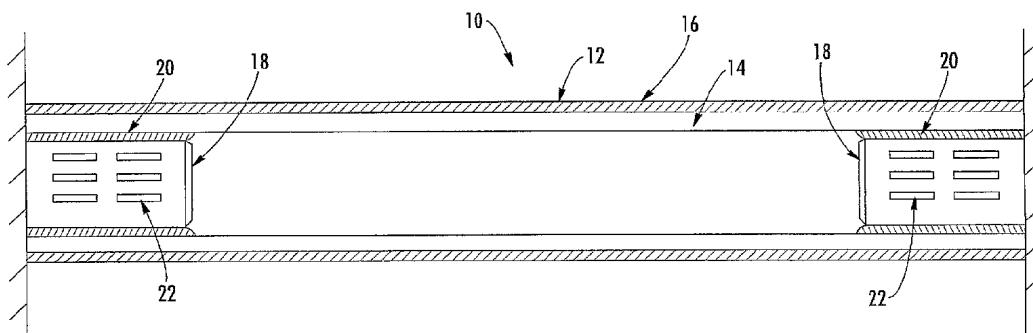
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(54) Title: WINDING CORE AND ASSOCIATED METHOD



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(57) **Abstract:** A winding core, a winding core assembly for winding web materials, and a method are provided. The winding core includes a hollow cylindrical core member having an inner surface, an outer surface, and first and second ends. A chuck-engaging layer is located on the inner surface of the core member, wherein the chuck-engaging layer is softer than the core member.

## WINDING CORE AND ASSOCIATED METHOD

### BACKGROUND OF THE INVENTION

#### Field of the Invention

The present invention relates to winding cores and, more particularly, to winding sheets of paper, film, and the like into large rolls and a method of winding 5 such sheets onto a core.

#### Description of Related Art

Web materials such as polymer film, paper, nonwoven or woven textile, metal foil, sheet metal, and others, are used to manufacture a variety of products. The web materials are generally provided in the form of large rolls formed by 10 winding the web material about a winding core. The core is generally paperboard, though it may be reinforced with a plastic outer shell or the like. The paperboard may be formed of high strength, high density paperboard plies. A roll of paper or the like wound onto the core typically has a weight above two tons and often exceeding five tons. Typical core sizes are an internal diameter of 3 in. (76.2 mm.) 15 to 6 in. (152.0 mm.) or 150.4 mm. in Europe, and a length of about 100 to 140 in. To begin the winding process, a tail end of a web is attached to the winding core and the core is rotated about its axis to wind the web into a roll. The rolls are subsequently unwound during a printing or similar process.

Web converters such as printers or the like continually strive to increase 20 productivity of converting processes by increasing the total amount of web throughput per unit time. To this end, there has been a continual push toward wider webs and higher web speeds, which lead to longer winding cores that must rotate at higher rotational speeds and must support heavier rolls of the wider web material. For instance, rotogravure printers are currently developing 4.32 m. wide 25 printing presses for high-speed printing. Paper supply rolls for such presses would weigh in excess of 7 tons. Applications such as this place extreme demands on the stability of current winding cores. A potential solution to the problem is to

increase core stiffness by increasing core diameter, but this would be undesirable if it meant that the cores would not be compatible with existing winding and unwinding machinery, as would be the case if the inside diameter of the core were increased.

5 During a winding or unwinding operation, a core is typically mounted on a rotating expandable chuck that is inserted into each end of the core and expanded to grip the inside of the core so that the core tends not to slip relative to the chuck as torque is applied therebetween. Typically, the rotation of the core is achieved by means of a drive coupled to one or both of the chucks, and the core is rotated to  
10 achieve web speeds of, for example, 15 to 16 m/s. The rolls of material are often subjected to substantial circumferential acceleration and deceleration by the winding machines. This, in turn, subjects the engaged ends of the paperboard roll to substantial torque forces. This often leads to some slippage of the chuck on the inside of the core. In an extreme situation, the slippage can lead to "chew-out"  
15 wherein the core is essentially destroyed by the chuck.

Aside from problems such as chew-out, the failure of the chuck to firmly grip the core can lead to other undesirable effects. In particular, it has been discovered that it can lead to a reduction in the "chuck factor" of the core, which is defined as the resonant frequency of the core when chucked, divided by the  
20 resonant frequency of the core when free. It is desirable for the chuck factor to be as high as possible without risking excessive vibration. The natural frequency of vibration of a core corresponds to that core's resonant frequency and may be calculated using the formula:

$$F = \frac{22.4 \times C_r}{2\pi} \times \left( \frac{E \times I}{m \times L^3} \right)^{\frac{1}{2}}$$

25 where F is the natural frequency of the core while chucked,  $C_r$  is the relative chuck factor, E is the modulus of elasticity of the core along its length, I is the moment of inertia, m is the mass of the core, and L is the length of the core.

Efficient winding requires that the natural frequency of the chucked core be higher than the core rotational speed during winding and unwinding, where the  
30 natural frequency depends upon the above factors and the way it is supported by

the chucks. A safety factor of 15 to 20% is typically taken into account, as there should be assurance that the maximum rotational frequency of the core while chucked will remain less than the natural frequency of the core. Current winding cores generally produce chuck factors of about 0.70 to 0.80, which limits the 5 percent safety factor and winding speed of the core without risking excessive vibration.

Accordingly, a need exists for an improved core that provides better grip to prevent the chuck from slipping and possibly damaging the core during winding and unwinding. In addition, a need exists for a core that provides for an improved 10 chuck factor.

#### BRIEF SUMMARY OF THE INVENTION

The invention addresses the above needs and achieves other advantages by providing a winding core with an improved gripping surface for a chuck and increased chuck factor. A chuck-engaging layer is disposed on a portion of the 15 inner surface of the core member to provide a gripping surface to allow the chuck to engage the winding core in a manner less susceptible to slippage between the chuck and core. In addition, a combination of the chuck-engaging layer, a longer winding core, and a longer chuck can allow the winding core to wind and unwind more material at traditional winding speeds without increasing the winding core 20 outer diameter substantially or sacrificing efficiency and safety.

In a first embodiment, a winding core includes a hollow cylindrical core member having an inner surface, an outer surface, and first and second ends. A chuck-engaging layer is affixed on the inner surface of the core member, wherein the chuck-engaging layer is softer than the core member.

25 In one variation, the core member comprises an inner layer defining the inner surface and an outer layer defining the outer surface. The inner layer comprises a paper-based material and the outer layer comprises glass fiber reinforced plastic. In addition, the chuck-engaging layer may comprise a polymeric material, such as polyurethane.

30 In additional variations, the length of the core member is about 4.32 meters. The outer diameter of the core member may be about 180 millimeters and the inner diameter may be about 154.4 millimeters. The chuck-engaging layer may be about

2 millimeters thickness bringing the diameter to 150.4 millimeters. Preferably, each chuck-engaging layer extends a portion of the length of the core member proximate to each of the first and second ends such that the layer does not extend the entire length of the core.

5 In yet another embodiment, a winding core assembly includes a hollow cylindrical core member having an inner surface, an outer surface, and first and second ends. A chuck-engaging layer is located on the inner surface of the core member, wherein the chuck-engaging layer is softer than the core member. Also, a chuck is operable to engage the chuck-engaging layer on the inside surface at the 10 first end of the core member such that the chuck is coupled to the core member. The chuck may comprise a double row of expanding elements for engaging each of the chuck-engaging layers. Preferably, the assembly further comprises a second chuck operable to engage the chuck-engaging layer at the second end. Additionally, each chuck may be about 500 millimeters in length and have an 15 active length of about 420 millimeters, wherein the chuck-engaging layer extends at least 420 millimeters in length proximate to the first and second ends such that each chuck is operable to engage each chuck-engaging layer.

The assembly may further include a motor coupled to one chuck, wherein the motor drives the chuck about an axis of rotation extending longitudinally 20 through the core member. In one version, the winding core assembly achieves a chuck factor of at least 0.85.

The present invention also provides a method for winding web material. The method includes providing a hollow cylindrical core member having an inner surface, an outer surface, and first and second ends. The method also includes 25 affixing a chuck-engaging layer to the inner surface of the core member, wherein the chuck-engaging layer is softer than the core member. The method further includes engaging a chuck to the chuck-engaging layer on the inside surface at the first end of the core member such that the chuck is coupled to the core member. The method lastly includes rotating the chuck about a longitudinal axis extending 30 through the core member such that a web material is wound about the outer surface of the core member.

In variations of the method of the present invention, the chuck may rotate the core member at a chuck factor of at least 0.85. In addition, the affixing step may comprise coating the inner surface of the core member with a material such as polyurethane while the core member is rotating. Also, the affixing step preferably 5 comprises affixing the chuck-engaging layer to localized regions of the core inner surface proximate to each of the first and second ends such that the chuck-engaging layer does not extend the entire length of the core member. A second chuck also preferably engages the chuck-engaging layer at the second end such that the second chuck is also coupled to the core member. The method may also 10 comprise rotating the chuck such that the web material is unwound from the core member.

The winding core assembly of the present invention advantageously provides for an improved winding core having a chuck-engaging layer applied to its inner surface, which enables chucks on either end of the winding core to grip 15 the chuck-engaging layer. The chuck-engaging layer is softer than the winding core material, such that the chuck can penetrate the chuck-engaging layer and create increased friction due to better contact with the winding core surface to prevent the chuck from slipping while the winding core is rotating.

The winding core assembly also can decrease the incidence of chew out, as 20 the chucks are able to grip the chuck-engaging layer lining the inner surface of the winding core. In addition, the chuck factor of the winding core is increased, which correspondingly allows the safety factor to be increased. Increasing the safety factor ensures that the winding core may be rotated at higher than typical winding speeds without risking excessive vibration.

25 Winding cores in accordance with the present invention can be much longer than typical winding cores, which permits an increased amount of material to be wound. Also, the chucks preferably are longer to adequately grip the longer and heavier winding core. The combination of the chuck-engaging layer, longer winding core, and longer chucks allows the winding core to wind and unwind more 30 material at current winding speeds without increasing the winding core outer diameter substantially or sacrificing efficiency.

## BRIEF DESCRIPTION OF THE SEVERAL VIEWS OF THE DRAWING(S)

Having thus described the invention in general terms, reference will now be made to the accompanying drawings, which are not necessarily drawn to scale, and wherein:

5       **FIG. 1** is a cross-sectional side view of a winding core in accordance with one embodiment of the present invention, mounted on chucks, illustrating each chuck engaging a chuck-engaging layer on an inner surface of the core;

10      **FIG. 2** is cross-sectional detail view of an individual chuck shown in **FIG. 1**, illustrating a double row of expandable elements that engage the chuck-engaging layer; and

**FIG. 3** is a flowchart of a method according to another embodiment of the present invention, illustrating a method of winding a web material onto the core.

## DETAILED DESCRIPTION OF THE INVENTION

15      The present invention now will be described more fully hereinafter with reference to the accompanying drawings, in which some, but not all embodiments of the invention are shown. Indeed, this invention may be embodied in many different forms and should not be construed as limited to the embodiments set forth herein; rather, these embodiments are provided so that this disclosure will satisfy 20 applicable legal requirements. Like numbers refer to like elements throughout.

     Referring now to the drawings and, in particular to **FIG. 1**, there is shown a winding core assembly **10**. The term "winding core" is not meant to be limiting, and it is understood that the term winding core can be any core, reel, tube, cylinder, or the like used in a winding operation. Winding may be used to wind and unwind 25 rolls of web materials such as polymer film, paper, nonwoven or woven textile, metal foil, sheet metal, and the like.

     In a preferred embodiment, **FIG. 1** illustrates that the winding core assembly **10** includes a winding core **12** having an inner shell **14** and an outer shell **16**. A pair of chucks **18** are located at either end of the winding core **12** and have 30 expandable elements **22** that engage a chuck-engaging layer **20** of the core. The chuck-engaging layer **20** is located at each end of the winding core **12**, and is

applied to improve the grip of the chucks **18**, as will be explained more fully below.

The inner shell **14** is typically a paperboard material, although the inner shell could be any suitable material for the winding core **12**. Generally, the 5 paperboard material has a density of at least  $0.5 \text{ g/cm}^3$  and even as great as  $1.1 \text{ g/cm}^3$ . It is preferred that the outer shell **16** is harder than the inner shell **14** and, thus, acts to reinforce the inner shell. Therefore, the outer shell **16** may be a plastic material such as glass fiber reinforced polyester, although it is understood that alternative reinforcing materials may be used for the outer shell. The glass fibers 10 may be oriented lengthwise or circumferentially, or both, within the outer shell **16**. In addition, it is understood that the winding core **12** could be a "homogeneous" tube wherein the entire core wall is formed of a single type of material, which is typical of most paperboard winding cores.

The inner shell **14** preferably has an outer diameter of about 177 mm., and 15 the outer shell **16** preferably has a thickness of about 1.5 mm. Therefore, the total outer diameter of the winding core **12** is about 180 mm. The inner diameter of the winding core **12** is preferably about 154.4 mm. (without the chuck-engaging layer **20** applied). Winding cores **12** are typically standard diameters to accommodate uniform tooling, as mentioned above, but it is understood that the winding core 20 may have various dimensions for both the inner and outer diameters of the winding core **12**, as well as the inner **14** and outer **16** shell thicknesses. The length of the winding core **12** in one embodiment is about 4.32 m (170 in.), while typical 25 winding core lengths **12** range from 100 to 140 in. Thus, the winding core **12** length according to the present invention can be longer than typical winding cores. However, it is understood that the winding core **12** could be various lengths depending on the specific web material being wound or other winding factors.

The chuck **18** preferably includes a double row of expanding elements **22** as shown in **FIG. 2**. Each expandable element **22** is capable of expanding radially outward from the chuck **18**, and both rows of expandable elements are disposed 30 about the entire circumference of the chuck. Thus, the double row of expandable elements **22** is capable of engaging the inner surface of the winding core **12** circumferentially and uniformly. In a preferred embodiment where the winding

core **12** is about 4.32 m. in length, a roll of paper wound on the winding core can approach a weight of 7 tons. The expandable element **22** on each chuck **18** located at the top of the winding core **12** thus supports the weight of the winding core in addition to the weight of the web material that is wound on the winding core at any 5 given time. Consequently, the expandable elements **22** are capable of producing a substantial amount of force on the winding core **12** to both rotate and support the winding core.

The chucks **18** are hydraulically activated, so that once the expandable elements **22** are engaged with the chuck-engaging layer **20**, the chucks apply a 10 constant pressure to hold the winding core **12** in rotational engagement. Typically at least one chuck **18** is coupled to a motor or the like to drive the winding core **12** in rotation when winding the web material onto the winding core **12**, while during unwinding at least one chuck is coupled to a brake that acts to stop the winding core from rotating. The winding core **12** is typically rotated at peripheral speeds of 15 15 m/s to 16 m/s, although various speeds could be employed with the present invention. In the illustrated embodiment, the chucks **18** have a length of about 500 mm.

Although the chucks **18** illustrated in FIGS. 1-2 include a double row of expandable elements **22**, it is understood that the chucks could have a single row of 20 expandable elements, or may alternatively not expand hydraulically but rather expand pneumatically or be cone pressed within the winding core **12**, as known by those skilled in the art. Each of the expandable elements **22** may also be different sizes and shapes to accommodate different winding cores **12** or a specific winding application. In addition, the chucks **18** could be activated by torque as opposed to 25 hydraulically. Different types and sizes of chucks **18** could also be implemented for different sized winding cores **12** or for different types of winding core materials. For example, the chuck **18** could be about 200 mm. as opposed to the longer 500 mm. chuck, where the longer chuck is more useful with longer windings cores **12**.

30 The chuck-engaging layer **20** is applied to the inner shell **14** of the winding core **12** at each end. The chuck-engaging layer **20** preferably extends at least the length of the chuck **18**, so that the chuck may engage the chuck-engaging layer

along its entire length. The chuck-engaging layer **20** is preferably softer than the material comprising the inner **14** and outer **16** shells so that the chuck **18** may engage the chuck-engaging layer and create a “gripping” effect, as the friction between the chuck-engaging layer and the winding core **12** is increased. In one embodiment the chuck-engaging layer **20** is a polymeric material such as polyurethane, although it is understood that the chuck-engaging layer could be any number of polymeric, elastomeric, or like materials. The chuck-engaging layer is applied uniformly and circumferentially about the inner shell **14** to a thickness of about 2 mm., and the inner diameter of the winding core **12** is 154.4 mm. prior to applying the chuck-engaging layer, such that the inner diameter becomes 150.4 mm., which is a standard winding core diameter size in Europe. In addition, if the chuck **18** has an actual length of 500 mm. and an active length of about 420 mm., the chuck-engaging layer **20** is preferably at least 420 mm. in length along the winding core **12**. This permits the full length of the expandable elements **22** of the chuck **18** to engage the chuck-engaging layer **20**.

The chuck-engaging layer **20** may be various materials such as a polymeric material as mentioned previously, but could also be any material that is softer than the winding core **12** material. It is understood that the thickness of the chuck-engaging layer **20** could be modified to accommodate different sized chucks **18** or winding core **12** inner diameters. Typically, standard winding core **12** inner diameters are used to prevent the expense and inconvenience of changing tooling and logistics problems, but it is understood that the chuck-engaging layer **20** thickness could be adapted for any winding core inner diameter. For example, the chuck-engaging layer **20** could be applied to winding cores **12** at least as large as 16 in. in inner diameter. Similarly, the length of the chuck-engaging layer **20** could be any length to accommodate different sized chucks **18**, and may even extend the entire length of the winding core **12** in other embodiments.

Therefore, the chuck-engaging layer **20** advantageously provides a surface that allows the chucks **18** to grip the winding core **12** to aid in preventing chew out, as well as increase the chuck factor to at least 0.70 and preferably at least 0.85. Testing has indicated that winding cores **12** having no reinforcing outer shell **16** may have a greater chuck factor than winding cores consisting of an inner shell **14**

and a reinforcing outer shell **16**. It is believed that the stiffness of the reinforcing outer shell **16** prevents the chucks **18** from “digging into” and properly engaging the inner surface of the winding core **12**. Therefore, when the chuck-engaging layer **20** is applied to the inner surface of the winding core **12**, the chucks **18** are  
5 better able to dig in and grip the inner surface of the core.

The chuck-engaging layer **20** can be applied with a spray gun to the inner surface of the winding core **12** while the winding core is rotated. The spray gun acts to direct the chuck-engaging layer **20** to a desired location within the winding core **12**, after which the chuck-engaging layer cures and adheres to the inner  
10 surface of the winding core. The spray gun can direct a two-component mixture of isocyanide and polyol together under pressure onto the inner surface of the winding core **12**. The mixture then cures within approximately 20 seconds to form the chuck-engaging layer **20**.

In one embodiment, the winding core **12** is both rotated and supported by a  
15 pair of rollers positioned below the winding core while the spray gun is inserted within the winding core and the chuck-engaging layer **20** is applied. This produces a uniform layer of chuck-engaging layer **20**, as the winding core **12** rotates so that the full inner circumference of the winding core is covered. The spray gun may be adjusted to modify the thickness and length of the chuck-engaging layer **20** applied  
20 to the inner surface of the winding core **12** to accommodate different sized chucks **18**. The spray gun may be handheld, mounted to a bracket, or mounted to a fixture or robot such that the chuck-engaging layer **20** may be applied manually or automatically. An example of a spray gun according to one embodiment of the present invention is that manufactured by Gusmer Corporation.

25 It is understood that alternative techniques could be utilized to apply the chuck-engaging layer **20** to the inner surface of the winding core **12**. For example, it is understood that various compositions could be used with the spray gun of the present invention to form the chuck-engaging layer **20**, along with various curing times. In addition, the chuck-engaging layer **20** could be applied with an adhesive  
30 in instances where the chuck-engaging layer is not applied with a spray gun. In this regard, the chuck-engaging layer **20** could be a sheet of polymeric material that is adhesively attached or fastened to the inner surface of the winding core **12**.

Also, the chuck-engaging layer **20** could be applied to portions of the inner surface of the winding core **12** as opposed to the entire circumferential surface of the winding core. Thus, the chuck-engaging layer **20** could be applied such that the expandable elements **22** of the chuck **18** engage those portions where the chuck-  
5 engaging layer **20** is applied.

Many modifications and other embodiments of the invention set forth herein will come to mind to one skilled in the art to which this invention pertains having the benefit of the teachings presented in the foregoing descriptions and the associated drawings. Therefore, it is to be understood that the invention is not to  
10 be limited to the specific embodiments disclosed and that modifications and other embodiments are intended to be included within the scope of the appended claims. Although specific terms are employed herein, they are used in a generic and descriptive sense only and not for purposes of limitation.

## THAT WHICH IS CLAIMED:

1. A winding core comprising:  
a hollow cylindrical core member having an inner surface, an outer surface,  
5 and first and second ends; and  
a chuck-engaging layer affixed on the inner surface of the core member,  
wherein the chuck-engaging layer is softer than the core member.
  
2. A winding core according to Claim 1, wherein the core member  
10 comprises an inner layer defining the inner surface and an outer layer defining the  
outer surface.
  
3. A winding core according to Claim 2, wherein the inner layer  
comprises a paper-based material and the outer layer comprises glass fiber  
15 reinforced plastic.
  
4. A winding core according to Claim 1, wherein the chuck-engaging  
layer comprises a polymeric material.
  
5. A winding core according to Claim 4, wherein the polymeric  
20 material of the chuck-engaging layer is polyurethane.
  
6. A winding core according to Claim 1, wherein the length of the core  
member is about 4.32 meters.  
25
  
7. A winding core according to Claim 1, wherein the core member is  
about 180 millimeters in outer diameter.
  
8. A winding core according to Claim 1, wherein the core member is  
30 about 154.4 millimeters in inner diameter.

9. A winding core according to Claim 1, wherein the chuck-engaging layer is about 2 millimeters in thickness.

10. A winding core according to Claim 1, wherein the chuck-engaging layer extends a portion of the length of core member proximate to each of the first and second ends such that the chuck-engaging layer does not extend the entire length of the core.

11. A winding core assembly comprising:  
10 a hollow cylindrical core member having an inner surface, an outer surface, and first and second ends;  
a chuck-engaging layer located on the inner surface of the core member, wherein the chuck-engaging layer is softer than the core member; and  
a chuck operable to engage the chuck-engaging layer on the inside surface  
15 at the first end of the core member such that the chuck is coupled to the core member.

12. A winding core assembly according to Claim 11, wherein the core member comprises an inner layer defining the inner surface and an outer layer  
20 defining the outer surface.

13. A winding core assembly according to Claim 12, wherein the inner layer comprises a paper-based material and the outer layer comprises glass fiber reinforced plastic.

25  
14. A winding core assembly according to Claim 11, wherein the chuck-engaging layer comprises a polymeric material.

15. A winding core assembly according to Claim 14, wherein the  
30 polymeric material of the chuck-engaging layer is polyurethane.

16. A winding core assembly according to Claim 11, wherein the chuck comprises a double row of expanding elements for engaging the chuck-engaging layer.

5 17. A winding core assembly according to Claim 11, further comprising a second chuck operable to engage the chuck-engaging layer at the second end.

10 18. A winding core assembly according to Claim 17, wherein each chuck is about 500 millimeters in length and has an active length of about 420 millimeters.

15 19. A winding core assembly according to Claim 18, wherein the chuck-engaging layer extends at least 420 millimeters in length proximate to the first and second ends such that each chuck is operable to engage each chuck-engaging layer.

20 20. A winding core assembly according to Claim 11, further comprising a motor coupled to the chuck, wherein the motor drives the chuck about an axis of rotation extending longitudinally through the core member.

20

21. A winding core assembly according to Claim 20, wherein the motor rotates the winding core assembly at a chuck factor of at least 0.85.

25

22. A method of winding a web material comprising:  
providing a hollow cylindrical core member having an inner surface, an outer surface, and first and second ends;

affixing a chuck-engaging layer on the inner surface of the core member, wherein the chuck-engaging layer is softer than the core member;  
engaging a chuck to the chuck-engaging layer on the inside surface of the core member at the first end such that the chuck is coupled to the core member;  
30 and

rotating the chuck about a longitudinal axis extending through the core member such that a web material is wound about the outer surface of the core member.

5 23. The method according to Claim 22, wherein rotating the chuck rotates the core member at a chuck factor of at least 0.85.

10 24. The method according to Claim 22, wherein the affixing step comprises coating the inner surface of the core member with a polyurethane while the core member is rotating.

15 25. The method according to Claim 22, wherein the affixing step comprises affixing the chuck-engaging layer proximate to each of the first and second ends such that the chuck-engaging layer does not extend the entire length of the core member.

20 26. The method according to Claim 25, further comprising engaging a second chuck to the chuck-engaging layer at the second end such that the second chuck is coupled to the core member.

27. The method according to Claim 22, further comprising rotating the chuck such that the web material is unwound off of the core member.

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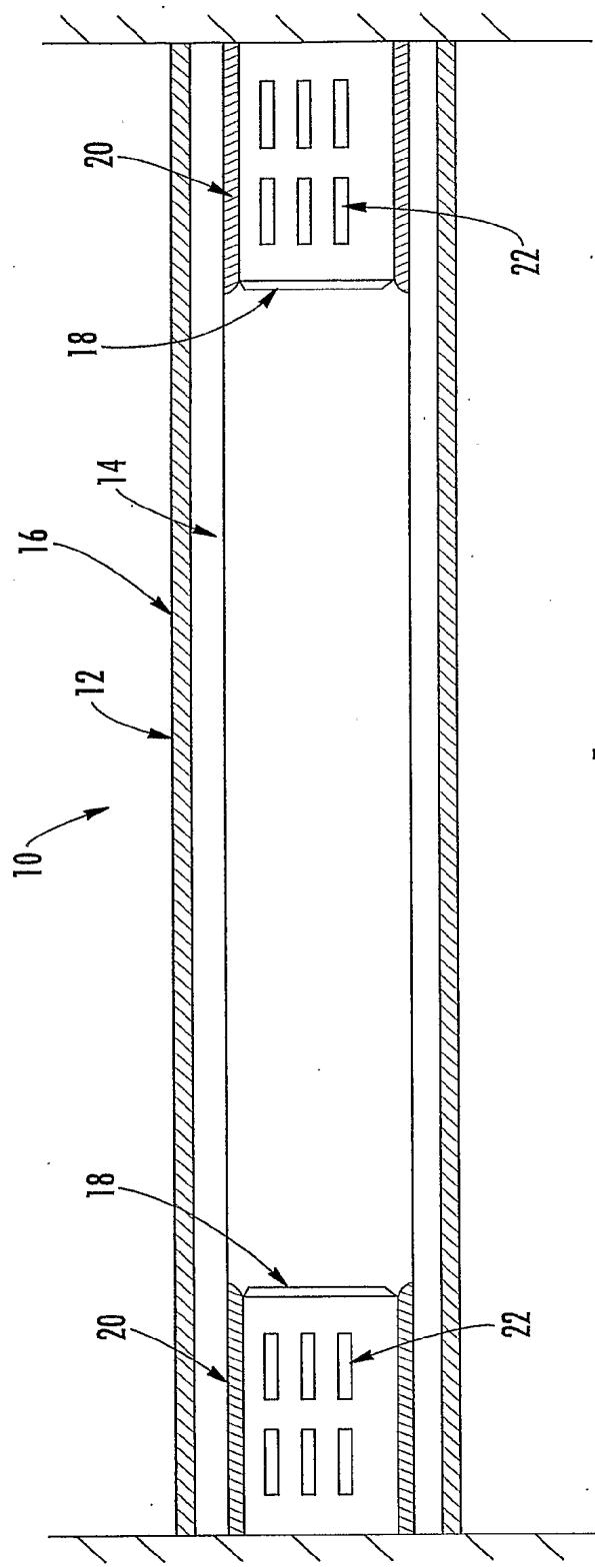


FIG. 1

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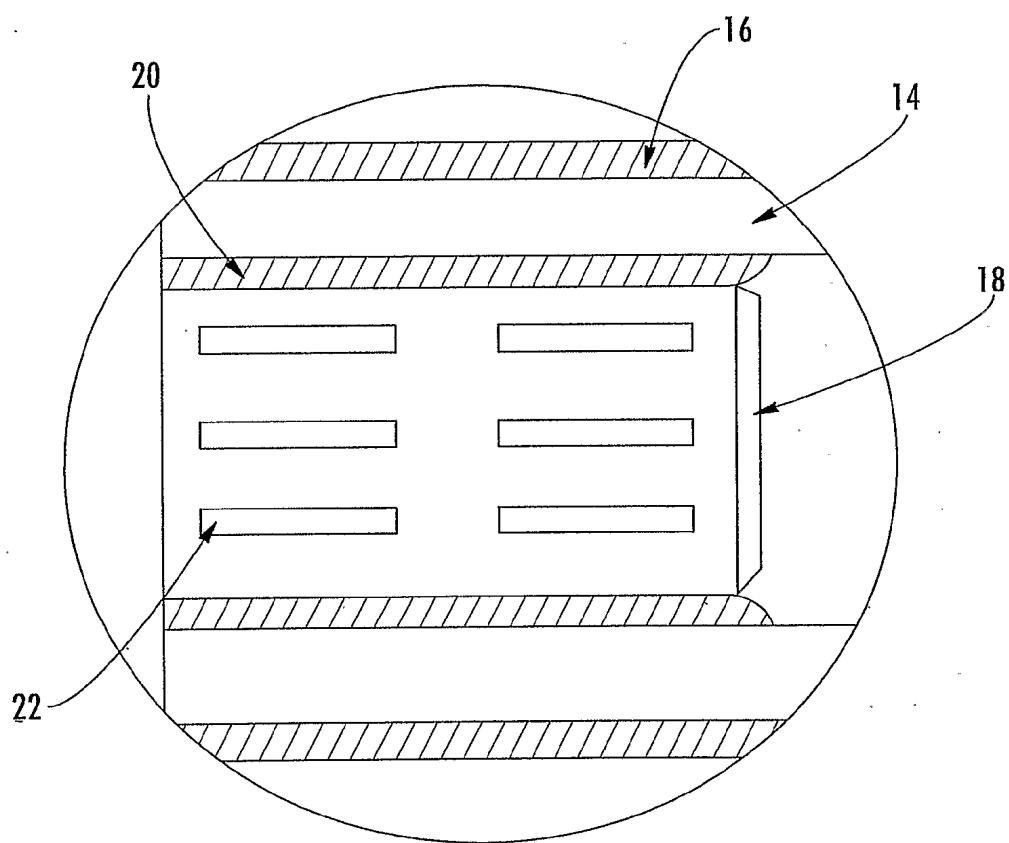


FIG. 2

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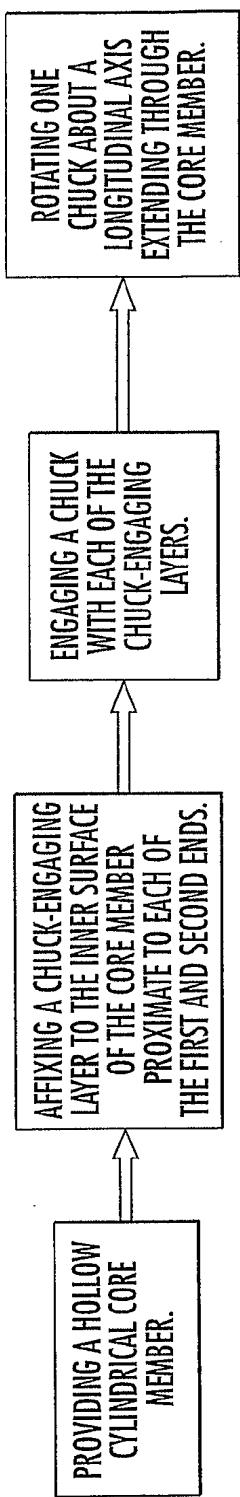


FIG. 3

# INTERNATIONAL SEARCH REPORT

International Application No  
PCT/US2005/005834

**A. CLASSIFICATION OF SUBJECT MATTER**  
IPC 7 B65H75/10 B65H18/02

According to International Patent Classification (IPC) or to both national classification and IPC

**B. FIELDS SEARCHED**

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 B65H

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, PAJ

**C. DOCUMENTS CONSIDERED TO BE RELEVANT**

Category <sup>o</sup>	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	PATENT ABSTRACTS OF JAPAN vol. 2002, no. 10, 10 October 2002 (2002-10-10) & JP 2002 179339 A (UBE NITTO KASEI CO LTD; SANWA SHOKO KK), 26 June 2002 (2002-06-26) abstract -----	1,11,22
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Further documents are listed in the continuation of box C.

Patent family members are listed in annex.

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Date of the actual completion of the international search

20 May 2005

Date of mailing of the international search report

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## INTERNATIONAL SEARCH REPORT

International Application No PCT/US2005/005834
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